WHAT IS CLAIMED IS:

1. A method for cutting a continuous work sheet being fed along a feed line of a cutting machine using a slitter which is disposed in the feed line and is moveable in upper and lower directions, wherein while the slitter is transferred from its previous cutting position to its new cutting position for a preparation for a change of a way of cutting the continuous work sheet from a previous way to a new way, the continuous work sheet is cut in such a manner that trimmed pieces form a continuous strip, said method comprising:

providing a trimming means disposed along the feed line in a position spaced apart from said slitter, said trimming means being movable in upper and lower directions, and said trimming means including a slitter blade being pivotable around an axis disposed vertically relative to the surface of said continuous work sheet,

moving said slitter from its previous cutting position to a position spaced apart from the surface of the continuous work sheet, while moving said trimming means toward the cutting position for the continuous work sheet, whereby said trimming means cuts into the trimmed pieces formed by said slitter in the previous way,

moving said slitter toward the cutting position for the continuous work sheet, while moving said trimming means from the cutting position for the continuous work sheet to a position spaced apart from the surface of the continuous work sheet, whereby said slitter begins to cut the continuous work sheet,

whereby the continuous work sheet is cut by said trimming means so as to bridge the trimmed piece formed in the previous

way and the trimmed piece formed in the new way.

2. The cutting method recited in claim 1 further comprising the steps of:

moving said trimming means toward the cutting position for the continuous work sheet immediately before moving said slitter from its previous cutting position to the position spaced apart from the surface of the continuous work sheet,

moving said trimming means from the cutting position for the continuous work sheet to a position spaced apart from the surface of the continuous work sheet immediately after moving said slitter toward the cutting position for the continuous work sheet.

3. The cutting method recited in claim 1 further comprising the steps of:

moving said trimming means toward its cutting position for the continuous work sheet at a location upstream from the downstream end of the trimmed line formed by said slitter in the previous cutting process,

moving said trimming means from the cutting position for the continuous work sheet to a position spaced apart from the surface of the continuous work sheet at a location downstream from the upstream end of the trimmed line formed by said slitter in the new cutting process.

4. The cutting method recited in claim 1 further comprising the step of moving said trimming means toward its cutting position for the continuous work sheet at the location outward of both of the

trimmed lines formed by said slitter in the previous and the new cutting processes, respectively.

5. The cutting method recited in claims 1 or 2 further comprising the steps of:

providing a rotational driving means, said rotational driving means rotating said slitter blade of the trimming means around an axis disposed vertically relative to the surface of said continuous work sheet,

cutting the continuous work sheet by said trimming means in a manner that a rotational position of said slitter blade of the trimming means is adjusted based on the feeding speed of the continuous work sheet and moving speed of the said trimming means in the width direction of the continuous work sheet.

6. The cutting method recited in claim 1 further comprising the step of providing said trimming means, said slitter, and a duct for containing the trimmed pieces therein, which are disposed in a direction from an upstream position toward a downstream position of the feed line of the continuous work sheet.